

Work Order ID 57818

April 16, 2010 10:36:37 AM



Page 1

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 16/04/2010 Start Qty: 24.00

Required Date: 29/04/2010 Req'd Qty: 24.00

Reference: *Ind 10.04.16*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 1.450" LONG

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV: *02*

DWG REV: *15*

DEBURR

Ind 10.04.19

Ind 10.04.19

24

Work Order ID 57818

April 16, 2010 10:36:37 AM



Page 2

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 16/04/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

10.4.17

24

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

SP 10/04/19

24

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

2) 10/04/20

24

HandFinish

Memo

0.00

Hand Finishing

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00

Memo

M114207
START: 8:15am
Temp: 320°F
FIN: 8:45am

0.00

=> Jd 10/04/21

24

Ø

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

(24)

10-4-21

170



Packaging

Packaging

Identify as per dwg & Stock Location:

G-A

0.00

Memo

0.00

EP 10/04/20 (24)

Work Order ID 57818

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Page 4

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 16/04/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/2010

MF
10-4-20

Picklist Print

April 16, 2010 10:36:37 AM

Page 1

Work Order ID: 57818

Parent Item: D3910-1

Parent Item Name: Crosstube Lug

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Start Date: 16/04/2010

Required Date: 29/04/2010

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	524.7499	3.2842			



Lug Extrusion



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT06

524.7499

43722

180

45800

344.7499

10-4-19 31

DART AEROSPACE LTD		Work Order: 57818
Description: X-703E LOG	Part Number: D3910-1	
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.45	+/- .030	4.455	/			
1.38	+/- .030	1.381	/			
.27	+/- .030	.278	/			
.31	+/- .030	.305	/			
.735	+/- .010	.725	/			
2.20	+/- .030	2.20	/			
.375	+/- .010	.375	/			
.191	+ .005 - .001	.194	/			
R.38	+/- .030	R.38	/			
.38	+/- .030	.38	/			
.625	+/- .010	.625	/			
.375	+/- .010	.375	/			
3.700	+/- .010	3.700	/			
.625	+/- .010	.625	/			
.375	+/- .010	.375	/			
R.34	+/- .030	R.34	/			

Measured by: <i>[Signature]</i>
Date: 10.4.18

Audited by: <i>[Signature]</i>
Date: 10/24/19

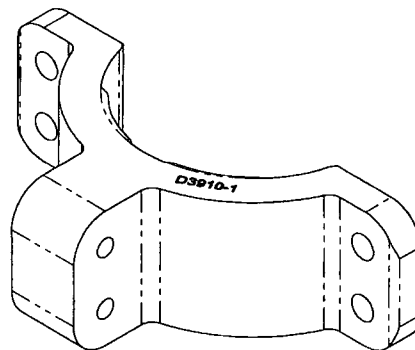
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

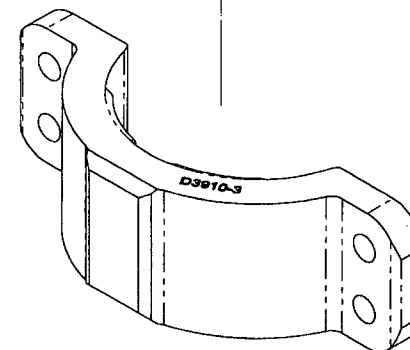


5S continued...

- **Standardize (Seiketsu) (清潔):** Standardizing. This refers to standardized work practices. This means operating in a consistent and standardized fashion. Everyone knows exactly what his or her responsibilities are.
- **Sustain (Shitsuke) (躰):** Sustaining. Refers to maintaining and reviewing standards. Once the previous 4S's have been established they become the new way to operate. Maintain the focus on this new way of operating, and do not allow a gradual decline back to the old ways of operating.



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

w/o 57B/81

RELEASED
2010-03-22
MD

NOTES:

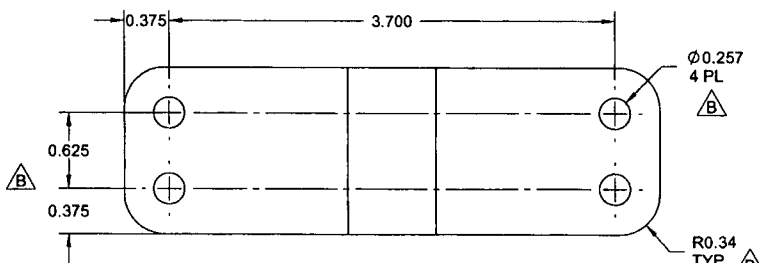
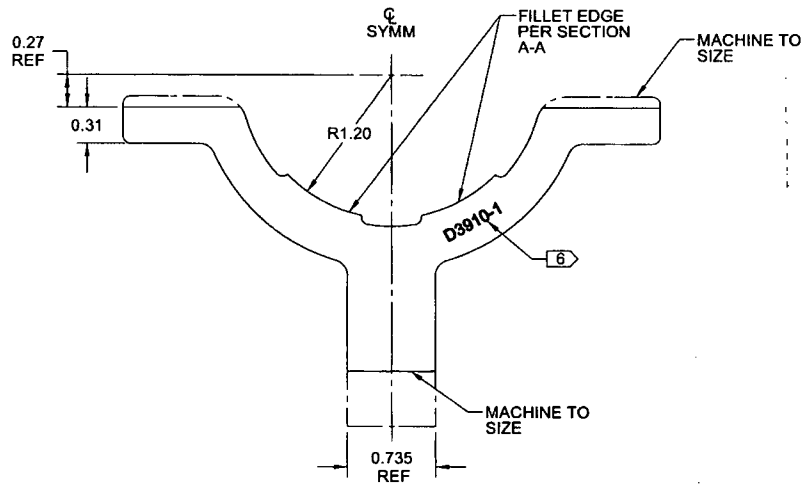
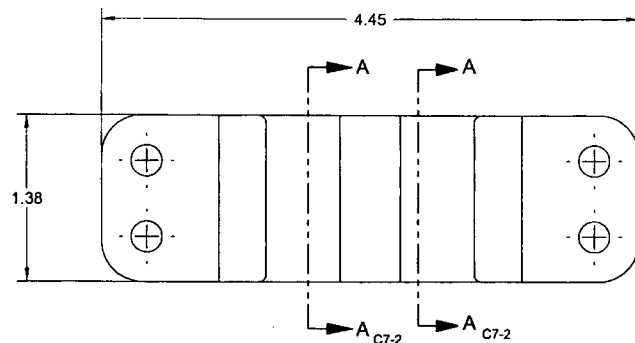
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D390-007-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3910 REV. B SHEET 1 OF 3 TITLE X-TUBE LUG (350) SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		
DRAWN	JPH			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>			
DATE	10.03.16			

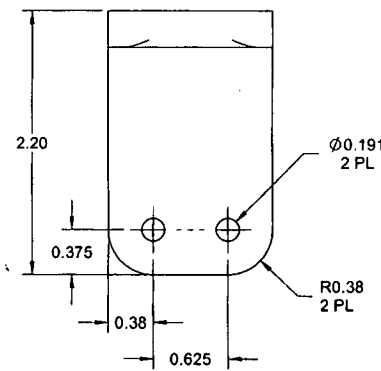


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL





SECTION A-A
C4-2
CS-2



D3910-1 X-TUBE LUG



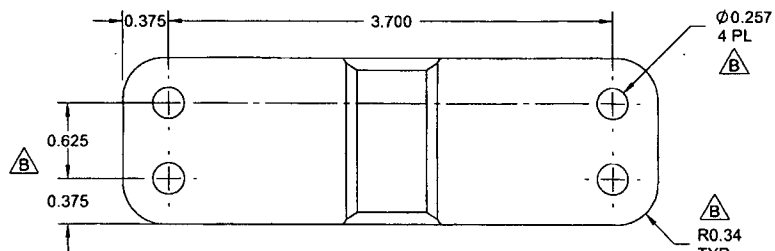
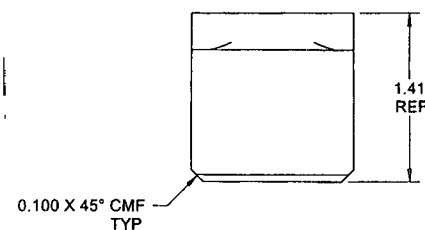
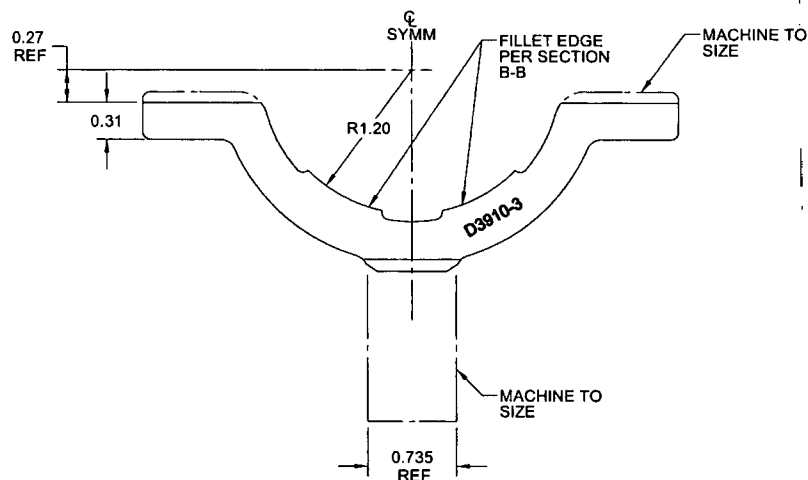
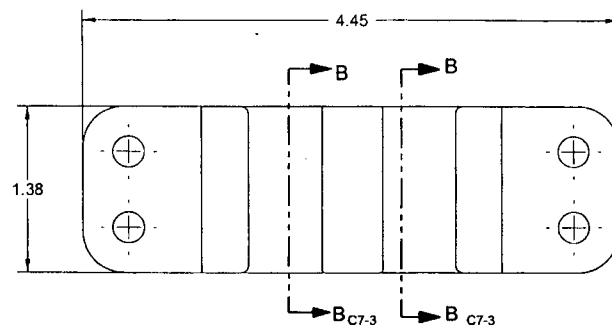
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2010-03-22
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

w/57818

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2010-03-22

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